

Work Order ID 84087

84087

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Wednesday, May 02, 2012 1:09:06 PM

Item ID: D2207-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Housing Body
 Start Date: 5/2/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: P Date: 1205-7 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2207	Rev C								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2207 Dwg Rev: C Prog Rev: C-2
 666-663 Debur if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

B12-5-16
B12-5-16
45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84087***84087***

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Item ID: D2207-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Housing Body

Start Date: 5/2/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

Bend as per dwg D2207

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: W/A

Memo

*****STOCK IN LARGE FAB*****

0.00

0.00

PJO
JB 7/26/18

(4)

(4)

EL 126-20

W/O: 84087		84087 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2207-1 PAR #: _____ Fault Category: Small Feb NCR: Yes No DQA: John Date: 12/6/26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: John Date: 12/6/27

NCR: 12-1524		WORK ORDER NON-CONFORMANCE (NCR) 49.00						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/19	100	1 part crack when handling operation R.C. Process	S 057047 12/06/19	had to change top + bottom die Scrap ~ testing no replace	S 12/06/19	S 12/06/19	S 057047 12/06/19	S 12/06/19
				usual die but material was problematic				

NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Housing Body

Start Date: 5/2/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

4

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/4/21 

12-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 1:09:10 PM

Page 1

Work Order ID: 84087

84087

Parent Item: D2207-1

D2207-1

Parent Item Name: Housing Body

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A01.03.08New Issue
IPP rev B 07.09.11 ecn 998 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	385.1422	0.4167	1.754526	2.5		

M6061T6S 063

6061-T6 .063 Sheet

**

13125-16

Location

Loc Qty

Loc Code

MAT021

385.1422000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

20.94

120218

19.5

120866

66.9426316

121578

160

121578

5

W/O:		WORK ORDER CHANGES					
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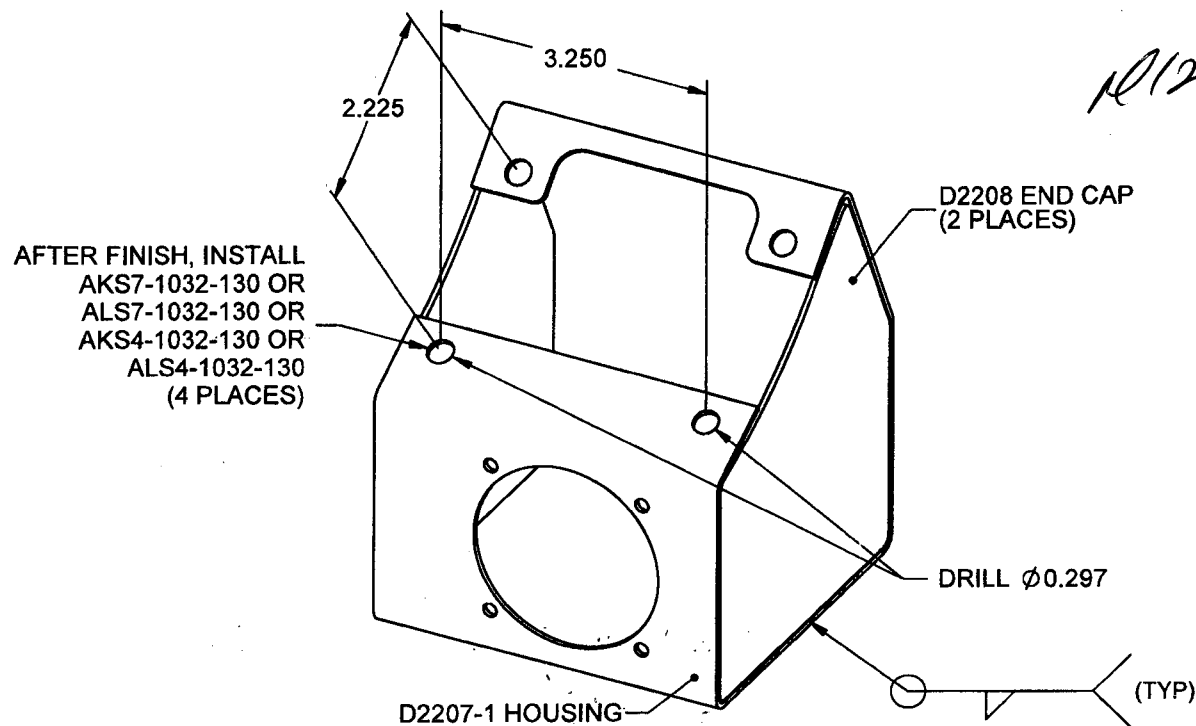
W/O:		WORK ORDER CHANGES					
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D2207-041 HOUSING ASSEMBLY

R1205-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84002

RELEASED

07.08.29 *[Signature]*

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2207	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HOUSING	1:2
DATE	07.06.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

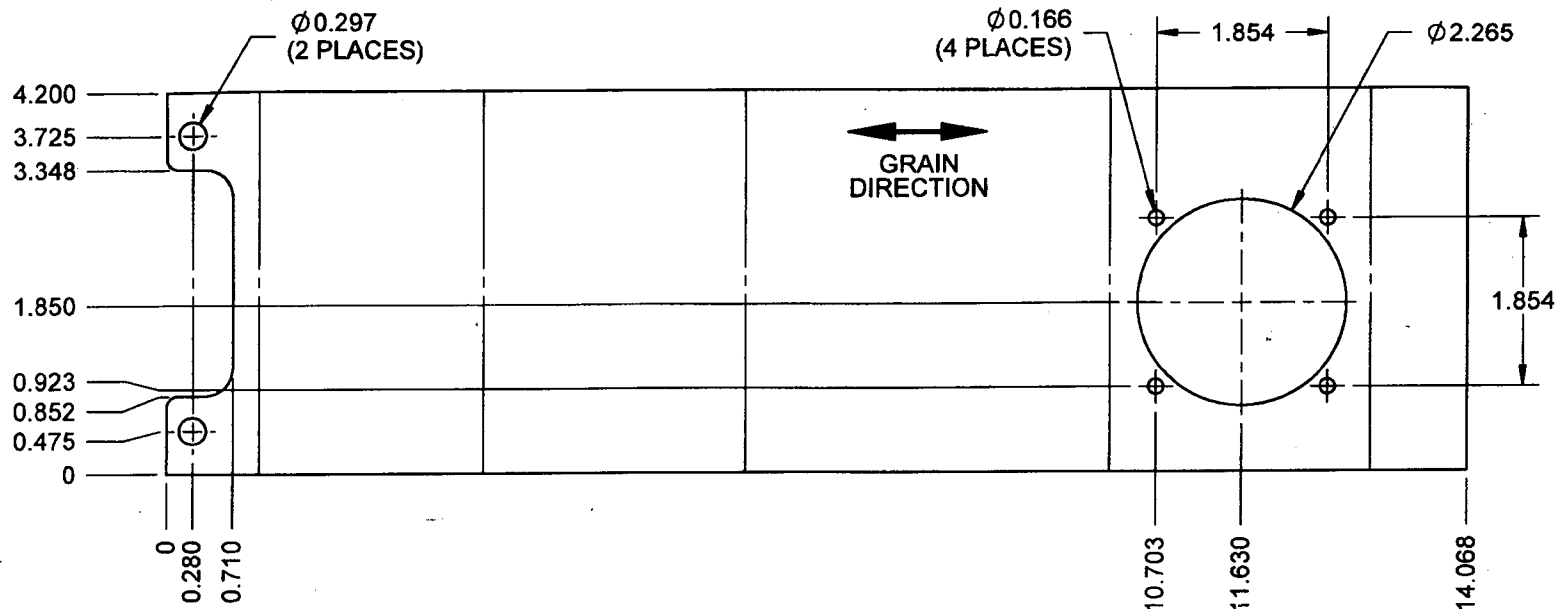
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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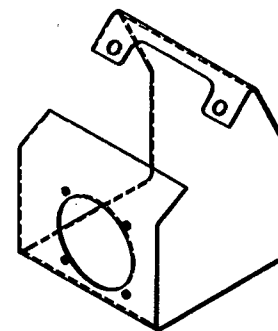


D2207-1F FLAT PATTERN

NOTES:

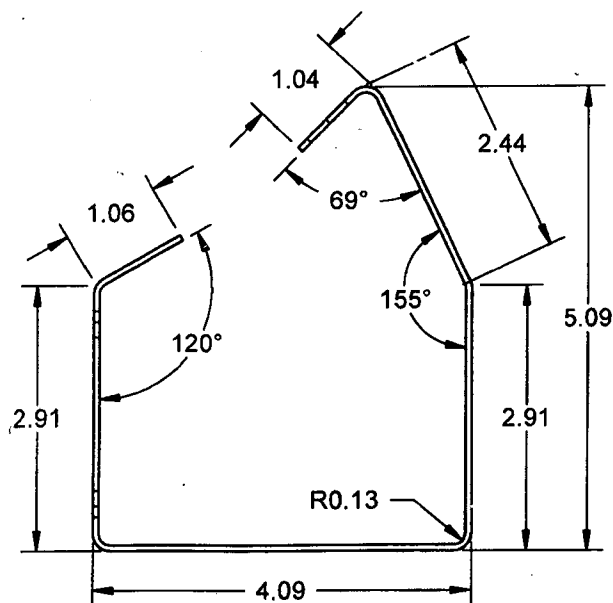
- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

84087



ISOMETRIC VIEW

(SCALE 1:4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 2 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	HOUSING	1:2
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